



Dart Aerospace Ltd.
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647.4312
Job Sheet 187534



Part No: 647.4312

Job Qty: 10 ea

Part Name: LH Upper Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/7/18

Job Tracking No:

Due Date: 12/31/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A SHEET 2 IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM IPP REV:B 14.11.06 CHG MATERIAL TO S.S. DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	10 pcs		12/31/18	0.00	0.99	Waterjet - Flow		OK 12/12/18
120	QC	10 pcs		12/31/18	0.00	0.00	QC2 Waterjet-1		OK 12/12/18
130	QC	10 pcs		12/31/18	0.00	0.00	QC8-1		38
140	Small Fab	10 pcs		12/31/18	0.00	3.88	Small Fab-1		WJ 9/18 JBL
150	QC	10 pcs		12/31/18	0.00	0.00	QC5		EL
160	Large Fab	10 pcs		12/31/18	0.00	6.45	Large Fab 1		JBL
170	QC	10 pcs		12/31/18	0.00	0.00	QC9		EL
180	QC	10 pcs		12/31/18	0.00	0.00	QC5		EL
190	SprayPaint	10 pcs		12/31/18	0.00	0.69	Spray Paint		RD 12-3-DAS
200	QC	10 pcs		12/31/18	0.00	0.00	QC14		MAR 15 2019 68
210	Packaging	10 pcs		12/31/18	0.00	0.00	Packaging3-1		MAR 15 2019 89
220	QC21-SA	10 Ea		12/31/18	0.00	0.00	QC21		21 9-88 MAR 15 2019

Part Op 110 - 1-Cut 6474300 plate 3.928X1.985 as per Dwg

Descriptions: 140 - 1- Fabricate tube as per dwg by cutting (22.00") one end 27.7 degree and other end punch, bend and drill hole as per dwg

160 - Weld tube to plate as per dwg.

190 - Prime as per dwg (see note 4)

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.5400 sf (.054 ea)	110-Waterjet - Flow - 1	
M304TR0.500W.049	304 Round Tube .500 X .049W	18.3000 ft (1.83 ea)	140-Small Fab	5133773



Container No: S136890



Part: 647.4312

Job No: 187534

Serial No/Batch: S136890

Revision:
Inspector:
Exp Date:
Instructions:

Date: 03/12/19

Locations

Required	Inventory	Allocated
1	51	0
18	226	0

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	LH Upper Strut	1.985inches $\pm$ 0.005	1.990 1.980		
2	LH Upper Strut	3.928inches $\pm$ 0.005	3.933 3.923		
3	LH Upper Strut	0.063inches $\pm$ 0.005	0.068 0.058		

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